

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015407**Date Inspected:** 02-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: Wuzhi Cheng
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: Yes No N/A
Approved WPS: Yes No N/A
Delayed / Cancelled: Yes No N/A

Bridge No: 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, M. Manikandan was present during the time noted above for observations relative to the work being performed.

OBG # Bay 1

This QA inspector performed dimensional survey on Traveler Rail. The measurements are recorded in the designated sheet and forwarded to team leader for further action. The Traveler rail designations reviewed are as follows:

20TR1-030

21TR4-003

21TR1-001

OBG # Bay 2

This QA inspector performed dimensional survey on Traveler Rail. The measurements are recorded in the designated sheet and forwarded to team leader for further action. The Traveler rail designations reviewed are as follows:

20TR1-011

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

OBG # TRIAL ASSEMBLY YARD (9AW-9BW)

Heat straightening of WT stiffener CJP weld joins 9AW and 9BW segment. ZPMC CWI is identified as Li Yang. Heat straightening was been performed due to misalignment more than 3mm observed in the below welds. The variables appeared to comply with the HSR1 (B)-8707 Rev.0 dated 29th June 2010. The weld designations reviewed are as follows:

BP097-001-25 to 36

BP043-001-25 to 36

BP151-001-25 to 36

BP098-001-31 to 42

BP044-001-31 to 42

For additional information please reference the pictures below:

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (9AW-9BW)

SMAW Process:

Welding of weld joint – 003 located on PCMK OBW9B, Bottom panel transverse splice weld joins 9AW and 9BW. Welder is identified as 067609. ZPMC CWI is identified as Li Yang. Welding was been performed against welding repair report B-WR13908. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-FCM-Repair-1

OBG # TRIAL ASSEMBLY YARD (9AW-9BW)

SMAW Process:

Welding of weld joint – 002 located on PCMK OBW9B, Side panel transverse splice weld joins 9AW and 9BW at counter weight side. Welder is identified as 067588. ZPMC CWI is identified as Li Yang. Welding was been performed against welding repair report B-WR13906. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G (3F)-FCM-Repair-1

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

No relevant conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Manikandan,Murugan
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Quality Assurance Inspector

Reviewed By:	Carreon,Albert
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QA Reviewer
